

**Work Order ID 73465**

Thursday, September 01, 2011 7:36:46 AM



Page 1

Item ID: D3204-13

Accept



Setup Start



Revision ID:

Item Name: Gusset

Stop



Start Date: 8/31/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: CL

Date: 11/09/01 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3204	Rev A1

100



FLOW WATER JET

0.00

11/11-9-15

Waterjet

Memo

FLOW CNC Waterjet

1-Cut as per Dwg D3204  Dwg Rev: A1  Prog Rev: A1  2-  
Deburr if necessary

(43)

6061 . 175

110



QC2- Inspect parts off machine FAI/FAIB

0.00

11/11-9-15

QC

Memo

Quality Control

120



QC8- Inspect parts - second check

0.00

Count

QC

Memo

Quality Control

0.00

X43

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 73465**

Thursday, September 01, 2011 7:36:46 AM



Page 2

Item ID: D3204-13

Accept



Setup

Start



Revision ID:

Item Name: Gusset

Stop



Start Date: 8/31/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 8.00



Customer:

**Reference:**

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



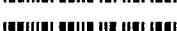
QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/  
Work Center ID****Operation  
Description****Set Up/  
Run Hours**

Tool ID

Tool #

**Plan  
Code****Accept  
Qty****Reject  
Qty****Reject  
Number****Insp.  
Stamp**

130

Identify as per dwg &amp; Stock Location:

0.00



Packaging

Memo

WA

0.00

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Thursday, September 01, 2011 7:36:43 AM

Page 1

Work Order ID: 73465



Parent Item: D3204-13



Parent Item Name: Gusset

Start Date: 8/31/2011

Required Date: 9/16/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP:  C  05.08.11  Added Step 25  KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased		No		100	sf	131.1700	0.0057	0.048	5		

6061-T6 .125 Sheet



Location	Loc Oty	Loc Code
MAT021	131.17	
113608	77.17	
118217	54	118217

113608  
118217

43

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	73465
Description: Gusset	Part Number:	D3204-13
Inspection Dwg: D3204	Rev: A1	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by: <u>R</u>	Audited by: <u>S</u>	Prototype Approval:	N/A
Date: 11-9-15	Date: 11/07/15	Date:	N/A

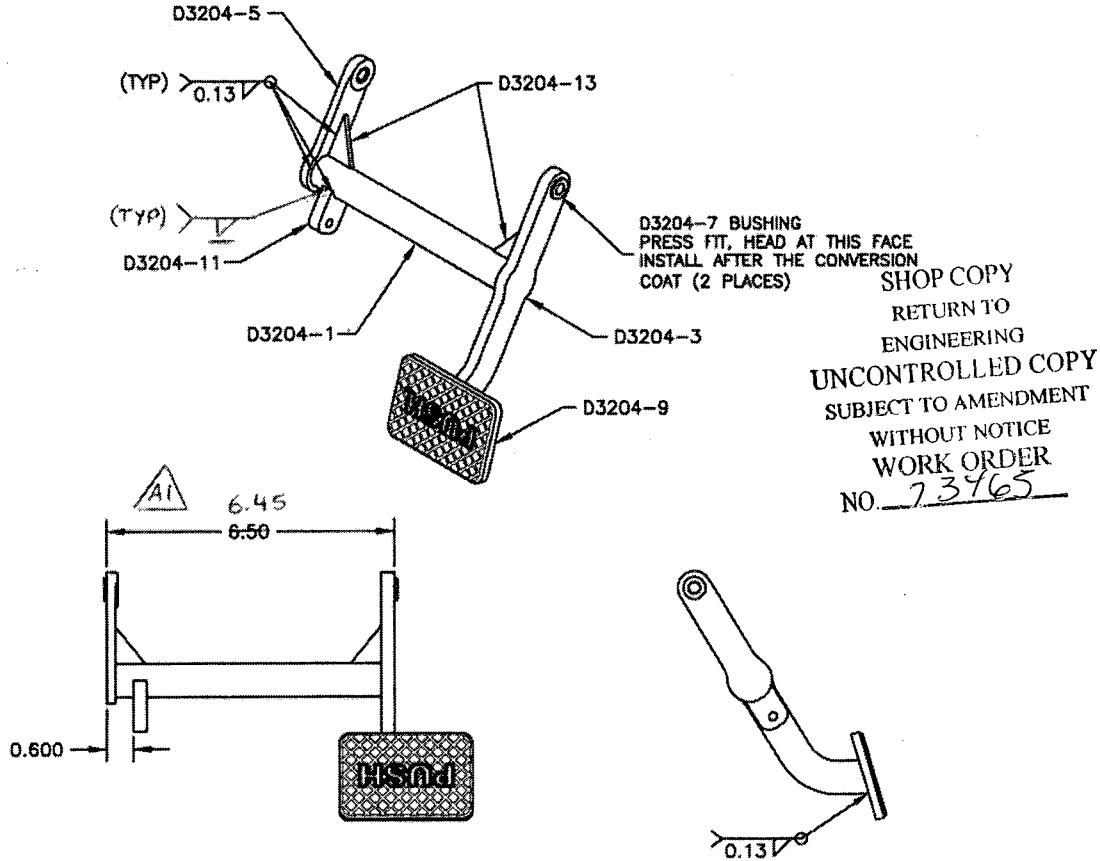
Rev	Date	Change	Revised by	Approved
A	09.05.04	New Issue	KJ/DD	AA



OF COPY ISSUED

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3204	SHEET 1 OF 3
DATE		TITLE	SCALE
04.01.27		RELEASE PEDAL ASSEMBLY	NTS
A	04.01.27	NEW ISSUE	
A1	05.07.15	6.45 WAS 6.50	

RELEASED  
04.04.30



### D3204-041 RELEASE PEDAL ASSEMBLY

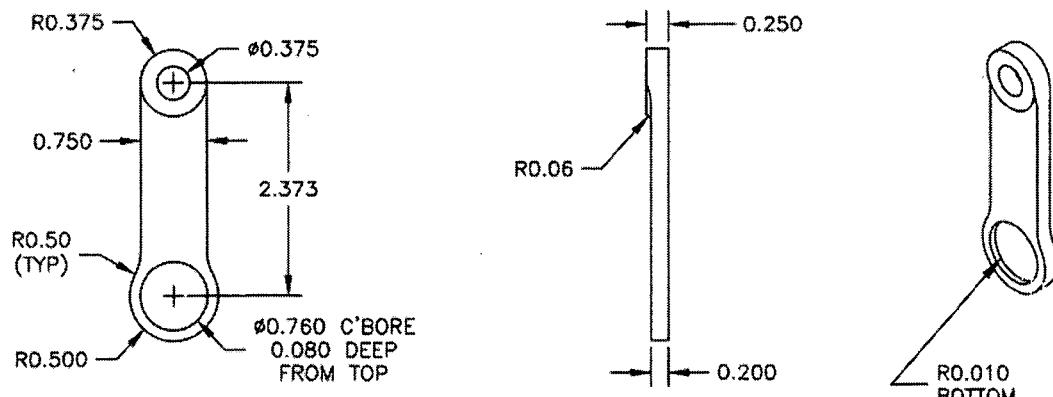
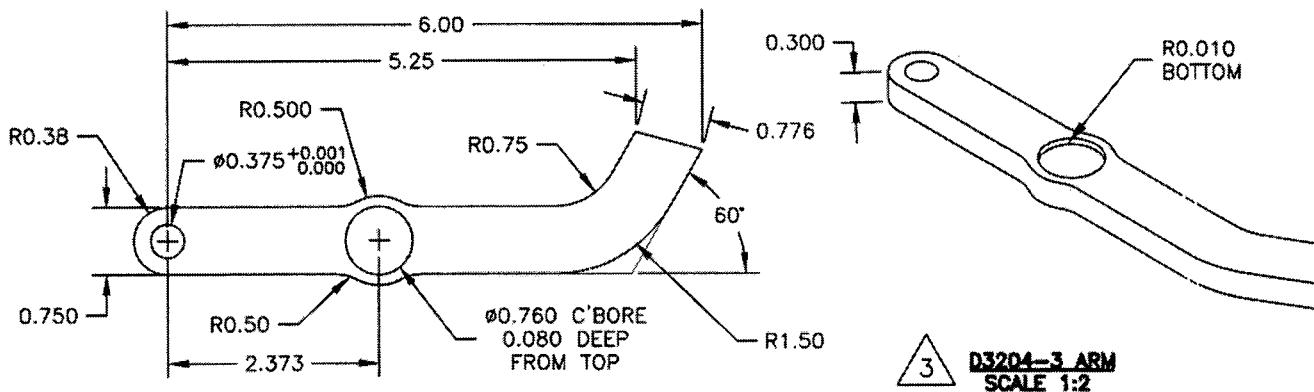
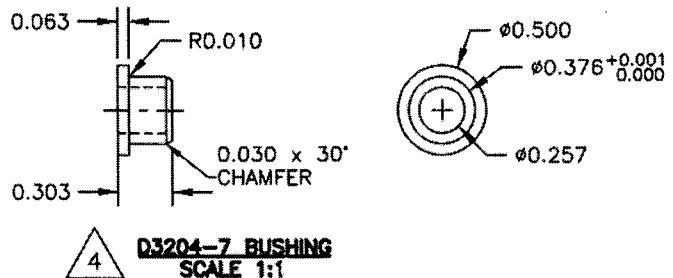
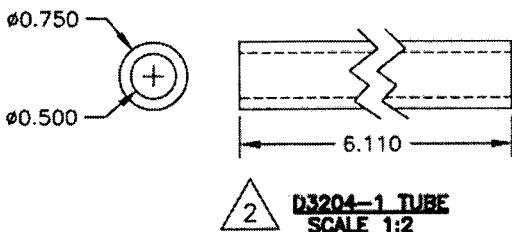
#### NOTES

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020  
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANTEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES



DESIGN RF	DRAWN BY TJ	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3204	REV. A SHEET 2 OF 3
DATE 04.01.27	TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS	

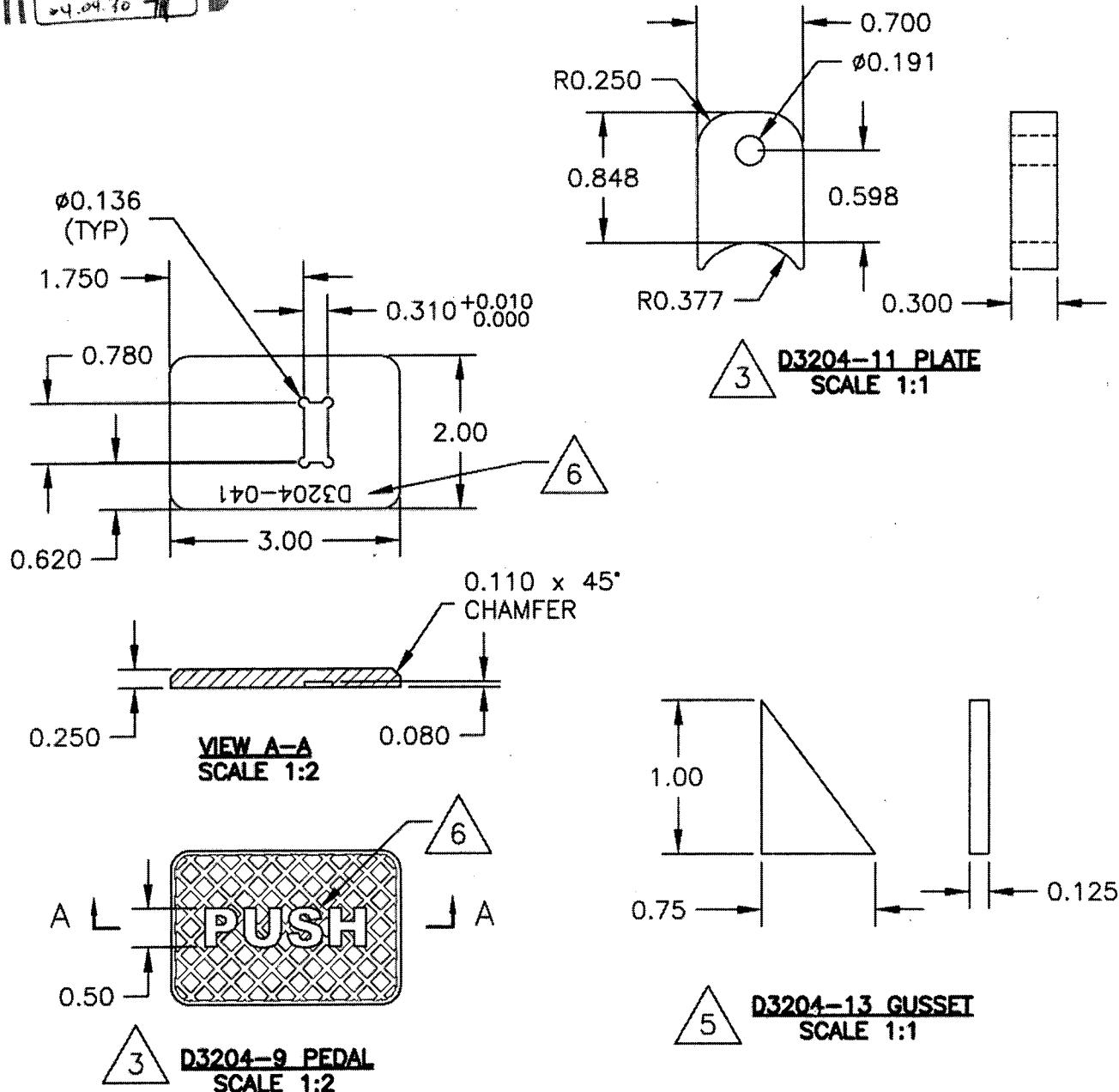
RELEASED  
04.04.05 #



3 D3204-5 ARM  
SCALE 1:2

**DART**COPY AS  
SPEC

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CH</i>	APPROVED <i>CH</i>	DRAWING NO. D3204	REV. A SHEET 3 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS

**RELEASED**  
4.04.70

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